

Thursday, 3/13/2008 8:38:22 AM
Johnston

Process Sheet

Drawing Name : R/H STEP ASSY
 Part Number : D3724042
 Drawing Number : D3724 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : ~~AUR~~ B PRELIM
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each
 Number : 37974
 Estimate Number : 13170
 P.O. Number :
 This Issue : 3/13/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 37533
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-02-07 DD verified by:



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

B36923

B29607

Check Material for any Dents or Defects

08-03-13 1
 08-03-13 1
 08-03-13 1

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-1 as per dwg D3737

B36923

2-Cut D3738-1 as per dwg D3738

B29607

3-Deburr and bevel ends for welding

08-03-13 1
 08-03-13 1
 08-03-13 1

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13 @

4.0 D37331 GUSSET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GUSSET

batch B37297

08-03-13 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 8:38:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 37974

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

08-03-13

08-03-13

6.0

QC9

VISUAL WELDING INSPECTION



ASS

ENGINEERING
APPROVAL



Comment: VISUAL WELDING INSPECTION

08-03-13

PD 08-03-13

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

08-03-13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-13

10.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

batch 336520

08-03-13

11.0

D37281

STEP BRACKET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PLATE

batch 37579

X

12.0

D37291

STEP BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE

batch 375800

X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 37974

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37301

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch B 37401 x (8)

14.0

D37411

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch B 37762 x (8)

15.0

MS20470AD511

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

batch M107100 x (3)

16.0

MS20470AD516

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch M107100 x (13)

17.0

CR321354

Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Cherry Rivet

batch M107100

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Apply Magnobond before installing rivets

A/R Magnobond 6398 Batch: M104677

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

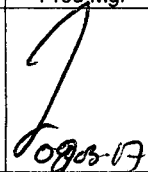
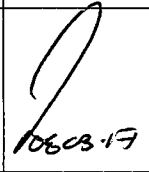
3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

(PTD)

MF 08-03-13 /
Ph 08-03-13 /
Ph 08-03-13 /

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.03-12	18-	(9) Took Rivets ms20470 AD516 and cut down to size to fit angle 3730-1. (instead of ms20470 AD511)	MF.	08.03-12	3	 10.03.17	 10.03.17	

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Date: Thursday, 3/13/2008 8:38:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 37974

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

~~108/03/13~~
19.0

~~5 reamed holes~~
LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PD →

Comment: LARGE FABRICATION RESOURCE 1

1-Apply magnabond as per dwg D3724

A/R Magnabond 6398 Batch: M106695

2-Rivet brackets in place on step as per dwg D3724

3-Weld both end cap as per Dwg D3724

4-Grind end cap welds flush

Inspect for foreign object per QSI 024

08-03-14 1
08-03-14 1
08-03-14 1
08-03-14 1

20.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-15

21.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

08/03/15

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



IX

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. / a.m. 08/03/15

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BL 08-03-17

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION




Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EX 08/03/17 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/14	to P.1	holes for center Brackets were drill in wrong location plus R.C. flange error	per per AS out 08-03-14	fill in all 8 ϕ 1.59" holes weld with weld as per AS204.			per per QSA out 08-03-14	 08/03/14
				Grind flush				
				Re Drill 0.159 holes in correct location.				

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 37974

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m/07385



Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

08/03/17 ①

26.0

QC5

INSPECT WORK TO CURRENT STEP



06.03.17 ①



Comment: INSPECT WORK TO CURRENT STEP

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 37725

08/03/17

08/03/17 ①

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/17

Job Completion



08/03/17

POSITIVE RECALL

EFFECTIVE 08/03/17 AUTH 1

RELEASED ADS DATE 08/03/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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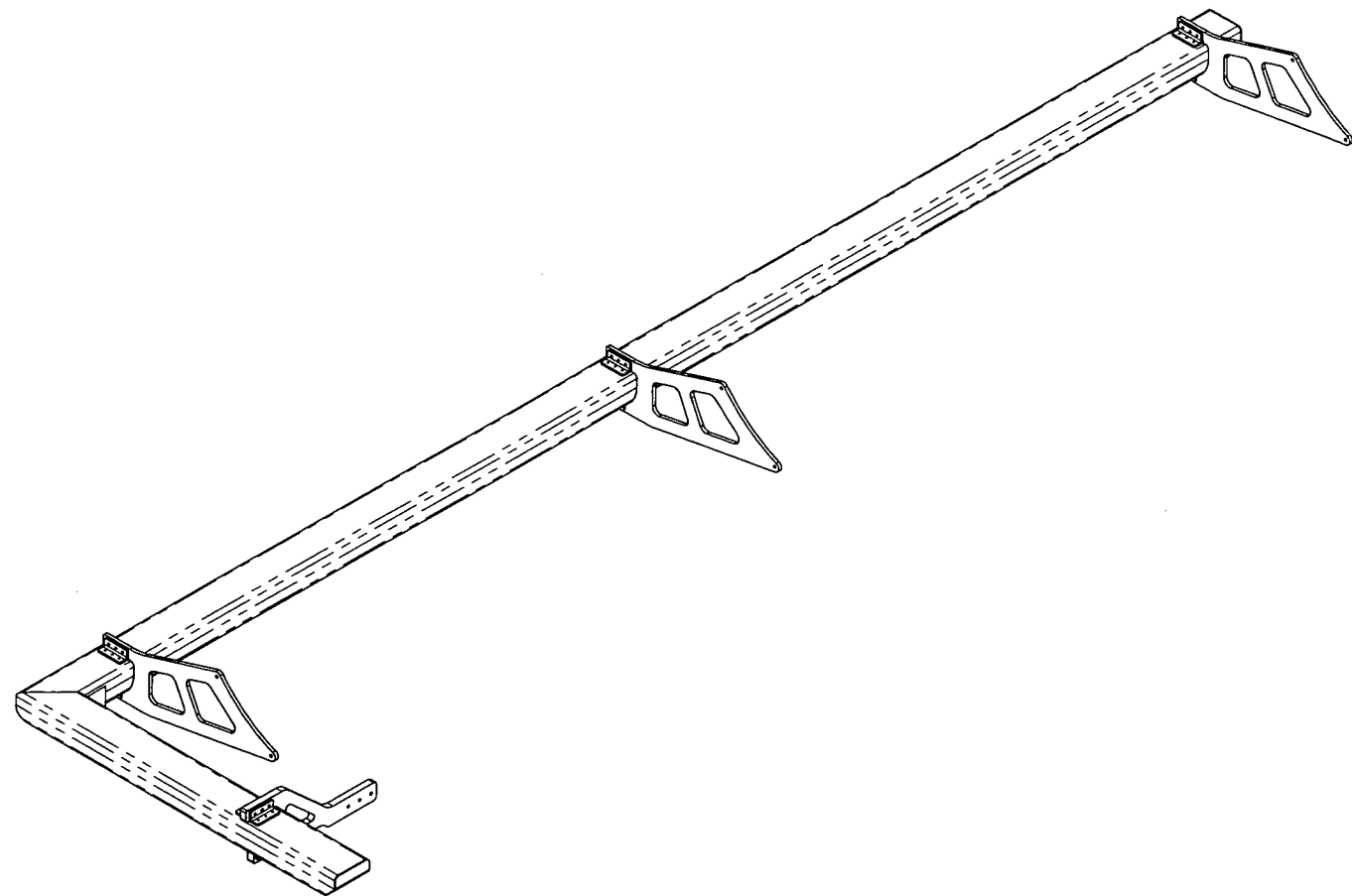
8 7 6 5 4 3 2 1

D

C

B

A



D3724-042 STEP ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.91 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED

QTY -042	P/N	DESCRIPTION
X	D3724-042	STEP ASSY
2	D2734-1	END PLATE
3	D3728-1	STEP BRACKET
1	D3729-1	STEP BRACKET
1	D3733-1	GUSSET
1	D3737-1	STEP
1	D3738-1	STEP
32	CR3216-5-4	RIVET
3	MS20470AD5-11	RIVET
1	MS20470AD5-16	RIVET
8	D3730-1	ANGLE
8	D3741-1	ANGLE

D

C

B

A

PRELIMINARY ISSUE

ASS 08.03.13

A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3724	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSY	NTS
DATE	08.02.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

